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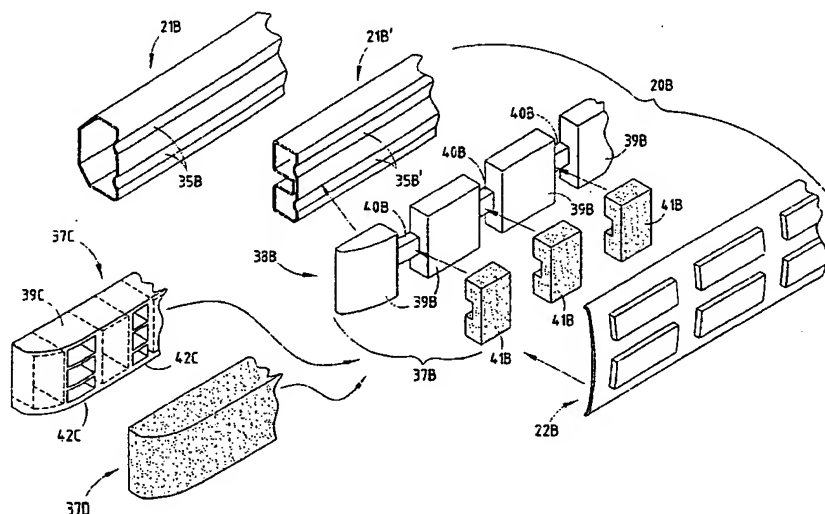
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(54) Title: **BUMPER SYSTEM INCORPORATING THERMOFORMED ENERGY ABSORBER**



(57) Abstract: A bumper system includes a tubular beam (21) and a thermoformed energy absorber with crush boxes (23) formed into a base flange, such as by vacuum or thermal forming processes. The crush boxes have planar energy-absorbing sidewalls a depth of about 10 mm to 35 mm, wall thickness of about 1 mm to 3 mm, and are formed from polyethylene or other thermoform materials having a memory. The base flange can include thermoformed features engaging recesses in the beam, and is combinable with injection-molded or foam energy absorbers for design flexibility. In one form, the energy absorber includes a thermoformed first sheet forming crush boxes and a second sheet bonded to the first sheet to define apertured air pockets. Related methods of manufacture and impacting are also disclosed.

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